

ABSTRACT OF THE DISCLOSURE

In a method for changing the section of a billet of a continuous casting plant during continuous casting, wherein opposed sides of the billet are in contact with oppositely positioned roll supports arranged below a continuous casting die, wherein the roll supports are comprised of segments having rolls, wherein adjoining ones of the segments of each roll support are connected to one another by a jointed connection and wherein each segment is configured to be adjustable independent of the other segments with respect to an angular position relative to the billet, and wherein in an initial position the segments of the roll supports are adjusted to a uniform billet section, a thickness reduction can be achieved by advancing sequentially in a direction of continuous casting the segments toward the billet by moving the jointed connections toward the billet in a controlled sequence of adjusting steps or a thickness increase can be achieved by moving sequentially in a direction of continuous casting the segments away from the billet by moving the jointed connections away from the billet in a controlled sequence of adjusting steps.